



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

D3253-1

Job Sheet 167932



Part No: D3253-1

Job Qty: 2 ea

Part Name: Small Shelf



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 12/1/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/30/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	2 pcs		11/30/17	0.00	0.20	Waterjet1		SC
110	QC	2 pcs		11/30/17	0.00	0.00	QC2		SC DAS
120	QC	2 pcs		11/30/17	0.00	0.00	QC8		38
130	Brake NC	2 pcs		11/30/17	0.17	0.10	Brake NC 2		38
140	QC	2 pcs		11/30/17	0.00	0.00	QC5		38
150	HandFinish	2 pcs		11/30/17	0.00	0.20	HandFinish1		38
160	Powdercoat	2 pcs		12/1/17	0.00	0.09	Powdercoat4		38
170	QC	2 pcs		12/1/17	0.00	0.00	QC3		38
180	Packaging	2 pcs		12/1/17	0.00	0.00	Packaging3		38
190	QC21-SA	2 Ea		12/1/17	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 160 - START TIME: 11:45 OVEN TEMPERATURE: 300° FINISH TIME: 12:15

M135418.

DEC 12 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	3	309	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Lab ☐ Eng ☐ Te ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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S016475

 Small Shelf

PART NO: D3253-1
Revision: Start up Operation
Operation: Mfg Date: 12/01/17
Change No: Job No: 167932

Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Root Cause ☐ Setup/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____

DART AEROSPACE LTD		Work Order: 167532
Description: Small Shelf (Dual Battery Rack)		Part Number: D3253-1
Inspection Dwg: D3253 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23,291	1		UDC-87	
1.425	+/-0.010	1,427	1		Tape	
R0.19	+/-0.030	R0,19	1			
0.697	+/-0.010	0,699	1			
6.502	+/-0.010	6,501	1			
5.200	+/-0.010	5,201	1			
1.300 Pitch	+/-0.010	1,300	1			
Ø0.098	+0.005/-0.000	Ø0,101	1			
0.300	+/-0.010	0,302	1			
R0.13	+/-0.030	R0,13	1			
0.651	+/-0.010	0,656	1			
0.643	+/-0.010	0,649	1			
8.020	+/-0.010	8,022	1			
7.508	+/-0.010	7,506	1			
R0.13	+/-0.030	R0,13	1			
0.063	+/-0.005	0,063	1			
Grain along 23.289	N/A	OK	1			

Measured by: SC	Audited by: JAS 38-89	Prototype Approval:	N/A
Date: 17/12/01	Date: NOV 04 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue P/O D205-579-015	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							